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Claims

1. Water soluble salt cores for pressure casting manufactured by compacting a mixture of water soluble salts under pressure and by subsequently sintering said compacted mixture,
5 said mixture having, for 100 parts by weight of salt, between 4 and 5 parts by weight of borax, between 2 and 3 parts by weight of magnesium and from 0.5 to 2 parts by weight of graphite or talcum,
characterized in
that compaction occurs at a pressure of between 300 and 900 N/mm².
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2. The water soluble salt cores as set forth in claim 1,
characterized in
that the salt cores are sintered at 650 – 730 °C for between half an hour and 2 hours.
- 15 3. A method of manufacturing water soluble salt cores,
characterized by the steps of
- preparing a mixture of 100 parts by weight of salt, between 4 and 5 parts by weight of borax,
between 2 and 3 parts by weight of magnesium and 0.5 to 2 parts by weight of graphite or
talcum,
20 - compacting the mixture in a press at a pressure ranging between 300 and 900 N/mm²
- sintering the compressed salt cores at 650 – 730 °C for between half an hour and 2 hours.